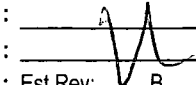


Date: Thursday, 15/05/2008 2:43:06 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : COVER  
 Job Number : 39184  
 Estimate Number : 10628  
 P.O. Number :  
 This Issue : 15/05/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D31381  
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3138 REV C  
 Previous Run : 39184 Project Number : N/A  
 Drawing Revision : C  
 Material :  
 Due Date : 30/05/2008 Qty: 4 Um: Each  
 Written By :   
 Checked & Approved By :  
 Comment : Est Rev: B 04.11.29 Made by Laser Cut KJ/RF  
 Est Rev: C 05.12.13 added level 5 EC  
 Est rev:D 08-05-12 now made on water jet DD verified  
 by:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S032 2024-T3 .032 sheet



ID



Comment: Qty.: 1.9348 sf(s)/Unit Total : 7.7393 sf(s)

2024-T3 .032 sheet

batch: 106272 IB 8-5-27

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3138

Dwg Rev: C IB 8-5-27

Prog Rev: C S

2-Deburr if necessary IB 8-5-27

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-5-27



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

808/05/27 (48)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

Bend as per Dwg D3138

FF 08-07-16 (5)

Date: Thursday, 15/05/2008 2:43:06 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 39184

Part Number: D31381

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 08/07/16 (X5)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

217/BR 08/07/16 (X8)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

11:50

OVEN TEMPERATURE:

320°F

FINISH TIME:

12:20 pm

911 08-07-16

(X5)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/07/16

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock with part number and batch number using fine point permanent ink marker as per view  
B-B top surface Dwg D3138

57145

8/4/16

(X5)

SD

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

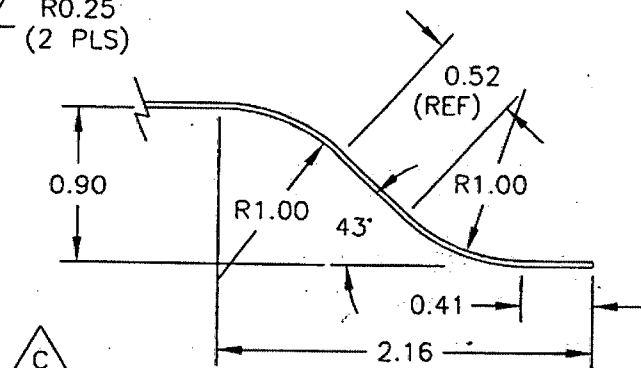
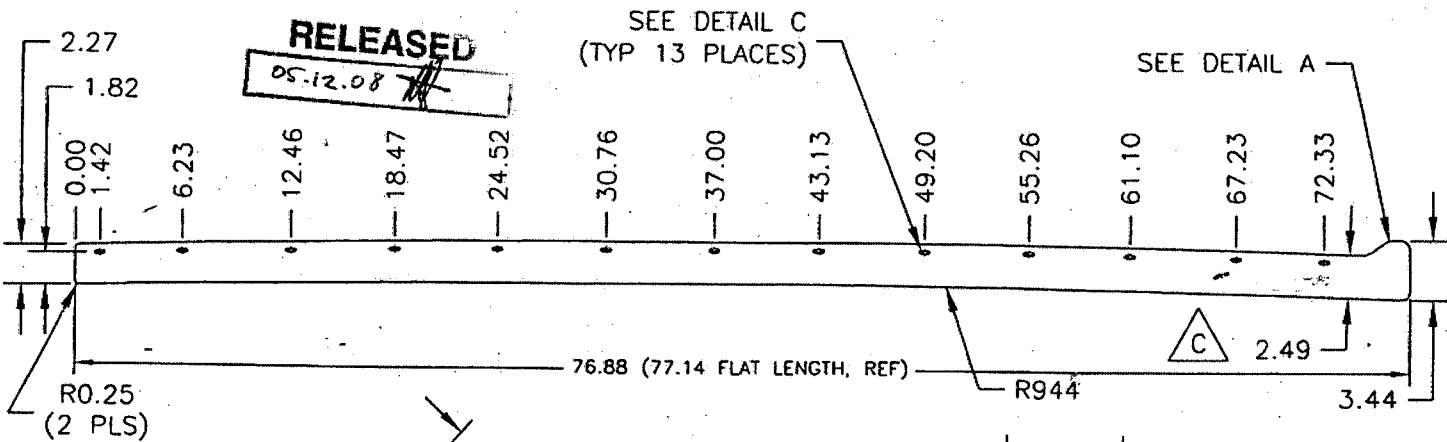
08/07/17

Job Completion

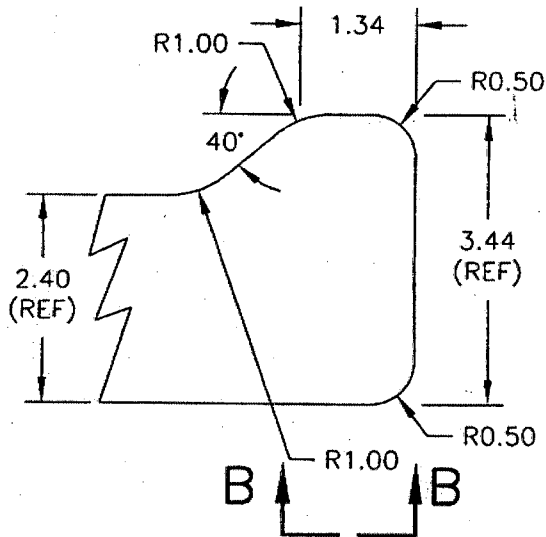
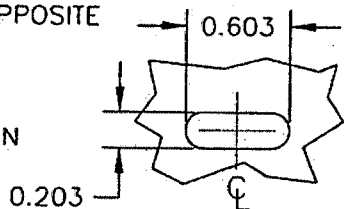


MF 08-07-16

**DART**



**DETAIL C**  
LOCATION DIMENSION  
TO CENTERLINE  
SCALE 1:1



**D3138-1 COVER (SHOWN REPLACES PREMIER P/N B30-23000-205)**

**D3138-2 COVER (BEND OPPOSITE. REPLACES PREMIER P/N B30-23000-206)**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DESIGN	CP	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAWESBURY, ONTARIO, CANADA
DATE	05.12.05	TITLE	D3138	REV. C
		COVER		SHEET 1 OF 1
				SCALE 1:10
A	02.04.18	NEW ISSUE		
B	04.09.20	RE-DESIGN		
C	05.12.05	CORRECT VIEW B-B; ADD 2.49 DIM.		

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39684

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39184
<b>Description:</b> COVER		<b>Part Number:</b> D3138-1
<b>Inspection Dwg:</b> D3138-1 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
603	+/- .010	606	*			
203	+/- .010	209	*			
1.82	+/- .030	1.814	*			
2.27	+/- .030	2.281	*			
2.49	+/- .030	2.492	*			
3.44	+/- .030	3.447	*			
1.42	+/- .030	1.425	*			
6.23	+/- .030	6.25	*			
12.46	+/- .030	12.46	*			
18.47	+/- .030	18.47	*			
24.52	+/- .030	24.52	*			
30.76	+/- .030	30.76	*			
37.00	+/- .030	37.00	*			
43.13	+/- .030	43.13	*			
49.20	+/- .030	49.20	*			
55.26	+/- .030	55.26	*			
61.10	+/- .030	61.10	*			
67.23	+/- .030	67.23	*			
72.33	+/- .030	72.33	*			
77.14	+/- .030	77.13	*			

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b> a
<b>Date:</b> 8-5-87	<b>Date:</b> 08/05/27	<b>Date:</b> 7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

